



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-642-251
Job Sheet 167493-A



Part No: D206-642-251

Job Qty: 1 ea

Part Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/1/17

Job Tracking No:

Due Date: 11/13/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/10/17	11/10/17	0.00	0.00	Start Up Skid tubes		
110	Skid tubes	1 pcs	11/10/17	11/10/17	0.00	10.15	Skid tubes		
120	QC	1 pcs	11/10/17	11/10/17	0.00	0.00	QC5 / QC9		PD 17-11-29
140	HandFinish	1 pcs	11/10/17	11/10/17	0.00	1.05	HandFinish1		2017-11-30 JSL
150	QC	1 pcs	11/10/17	11/10/17	0.00	0.00	QC7		BE
160	Skid tubes	1 pcs	11/10/17	11/10/17	0.00	3.38	Skid tubes		BE
170	QC	1 pcs	11/10/17	11/10/17	0.00	0.00	QC5 PD.		PD 17-12-06
180	Skid tubes	1 pcs	11/10/17	11/10/17	0.00	3.38	Skid tubes		J.Y. 17-12-12
190	QC	1 pcs	11/10/17	11/10/17	0.00	0.00	QC5		BE
200	Skid tubes	1 pcs	11/11/17	11/11/17	0.00	3.38	Skid tubes		BE J.Y.
220	QC	1 pcs	11/11/17	11/11/17	0.00	0.00	QC9		PD 17-12-12
230	QC	1 pcs	11/11/17	11/11/17	0.00	0.00	QC5		PD 17-12-12
240	HandFinish	1 pcs	11/11/17	11/11/17	0.00	1.05	HandFinish2		BE 17-12-18
250	Powdercoat	1 pcs	11/11/17	11/11/17	0.00	0.22	Powdercoat1		BE 17-12-19
260	QC	1 pcs	11/11/17	11/11/17	0.00	0.00	QC3		BE 17-12-20
270	HandFinish	1 pcs	11/11/17	11/11/17	0.00	1.05	HandFinish4		BE 17-12-20
280	HandFinish	1 pcs	11/13/17	11/13/17	0.00	3.14	HandFinish4		BE 17-12-20
290	QC	1 pcs	11/13/17	11/13/17	0.00	0.00	QC3		BE 17-12-21
300	QC	1 pcs	11/13/17	11/13/17	0.00	0.00	QC5		BE 17-12-21
305	DC	1 pcs	11/13/17	11/13/17	0.00	0.00	DC		
310	Packaging	1 pcs	11/13/17	11/13/17	0.00	0.00	Packaging3		
320	QC21-FG	1 Ea	11/13/17	11/13/17	0.00	0.00	QC21		

Part Op 110 - 1-Deburr Fwd edge of tube 2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804 3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required. Pick: Qty Part Number Description Batch A/R
Descriptions: per Dwg D3804. 4-Grind weld flush to cap on top surface only. 5-Cut Aft end as per Dwg D3804 from front of tube and Deburr 6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804 7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025 8-Drill pilot holes using Dt 8167, including #30 pilot at 1.25" from 15.450". Most fwd x-bolt hole must be laid out manually at 78.04" 9-Locate DT8732A from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732B & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732A & doubler leaving DT8732B for added support. 10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the s
160 - 1-Open holes to finished size to detail "B" as per Dwg D3804, (without cutting fluid) 2-C'sink ONE crossbolt spacer hole as per Dwg D3804 (Detail B)(without cutting fluid) 3-Deburr and blow out all chips from inside the tube
180 - 1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required 2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting Start Date: _____ Time: _____
Finish Date: _____ Time: Dec 6 Pick: Qty Part Number Description Batch A/R Sikaflex-791 M136654
Sikaflex expire date: 2018-04-21

DART
AEROSPACE
S014406

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**Replacement Skidtube, High Gear with Run – on Landing
Wearplates Fits LH or RH**

PART NO: D206 – 642 – 251

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/27/17

Job No: 167493 – A

200 - 1-Remove alodine per DEO detail B from around hole and prepare for welding 2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. Pick: Qty Part Number Description Batch A/R Aluminum Rod M136158/1383 3-Grind welds flush as per Dwg D3804. 4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required. A/R SS Rod None
 5-Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002 6- Debur
 250 - Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: 11:10
 OVEN TEMPERATURE: 320° FINISH TIME: 12:20
 270 - 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive. 2- Install D2680-041 Nut Plate as per Dwg D2650
 280 - 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/R Sikaflex-291 _____ Sikaflex expire date: _____ 2- Install wearplate as per dwg 2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: _____

305 - Photocopy bluefile & type labels per PPP D206-642-251 CHG004

310 - Identify and pack for shipping as per PPP D206-642-251 Location: _____ PPP Rev: _____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	CCR264SS3-3	2	276	0	0
	CR3212-4-03	2	233	0	0
	CR3212-4-04 <u>M137544</u>	52 <u>(54)</u>	247	0	0
	D2620 <u>5007246</u>	①	2	0	0
	D2647 <u>163996</u>	1	14	0	0
	D2654-3 <u>B165589</u>	1	4	0	0
200-Skidtubes	D3286-1 <u>F168695</u>	2	30	0	0
	D2649 <u>B146930</u>	1	130	0	0
	D3286-3 <u>E91160</u>	2	34	0	0
	D4720-1 <u>5014595</u>	19	302	0	0
	AN3-37A <u>5004853</u>	7	40	0	0
	D2651-1 <u>F163288</u>	8	173	0	0
270-HandFinish	D2651-3 <u>F164534</u>	8	421	0	0
	D2680-041 <u>F158428</u>	1	74	0	0
	D3805-043 <u>M138607-113</u>	1	1	0	0
	D3805-047 <u>M133198-112</u>	1	1	0	0
	D3873-1 <u>F160419</u>	14	171	0	0
	MS21042L3 <u>F M135945-1</u>	7	1,237	0	0
	MS27039-1-08 <u>F M138209-1</u>	2	480	0	0
	MS27039-4-06 <u>F M137951-1</u>	1	80	0	0
	NAS1149C0332R <u>F M138461-1</u>	7	4,324	0	0
	NAS1149D0332J <u>5020606</u>	2	1,552	0	0
	NAS1149D0463J <u>5014733</u>	1	1,725	0	0
	D2646 <u>M163254-102</u>	1	150	0	0
280-HandFinish					

Part Specifications

Specifications could not be found.

270- CCR 264SS3-3 x2 - FM137622.
 270- CR 3212-4-03 x2 - FM137886-0

Plex 11/1/17 1:21 PM dart.Michaud-Febrille.Victoria

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 167493-A

UM 17/11/1

DEO ATTACHED

RELEASED

UP 09.03.03
per ECN 09-530

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	99		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.07		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

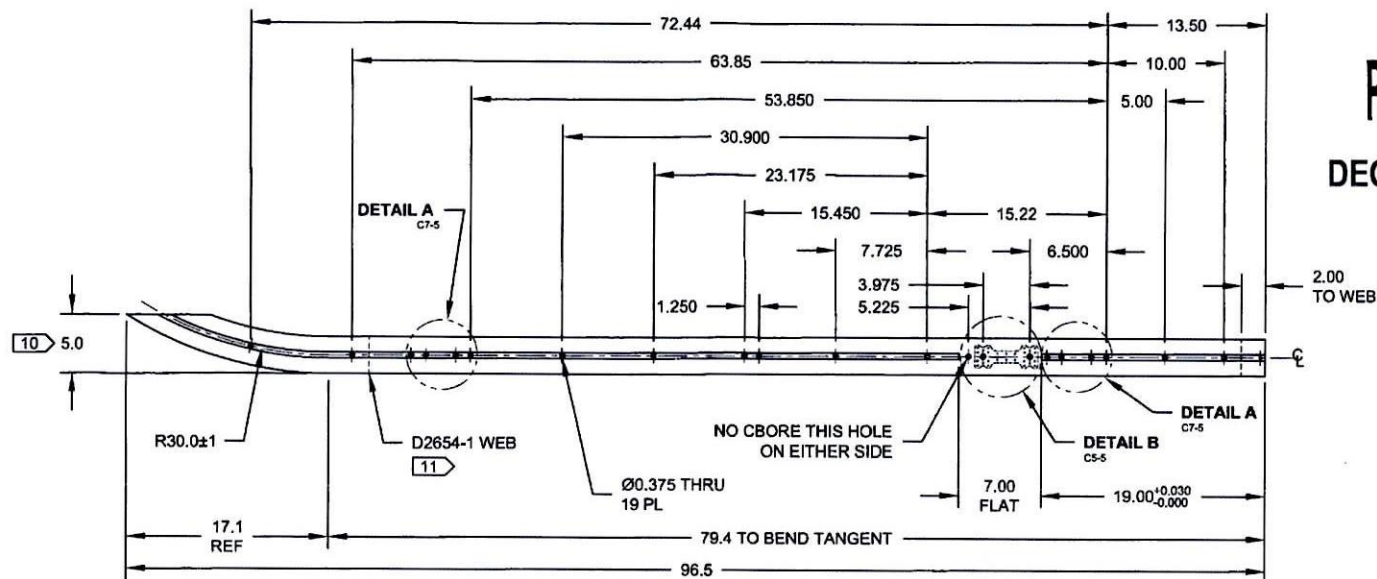
DRAWING NO. D3804 REV. A SHEET 1 OF 5

TITLE SKIDTUBE ASSEMBLY, 206A/B SCALE NTS

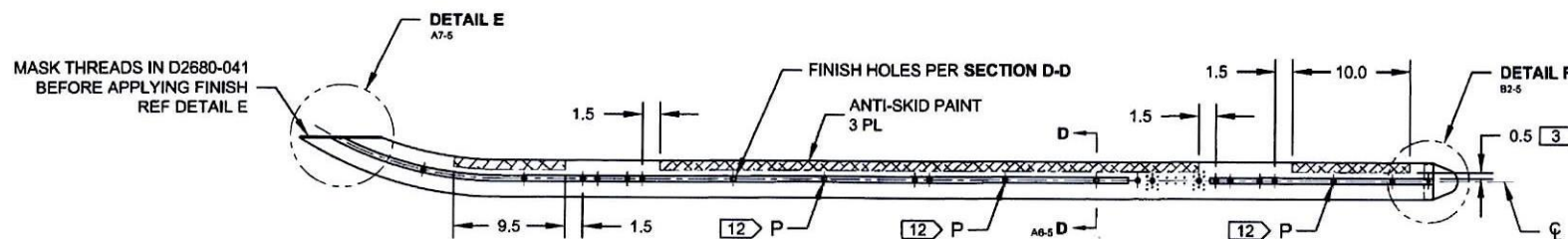
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D3804-041 BENDING/DRILLING DETAIL

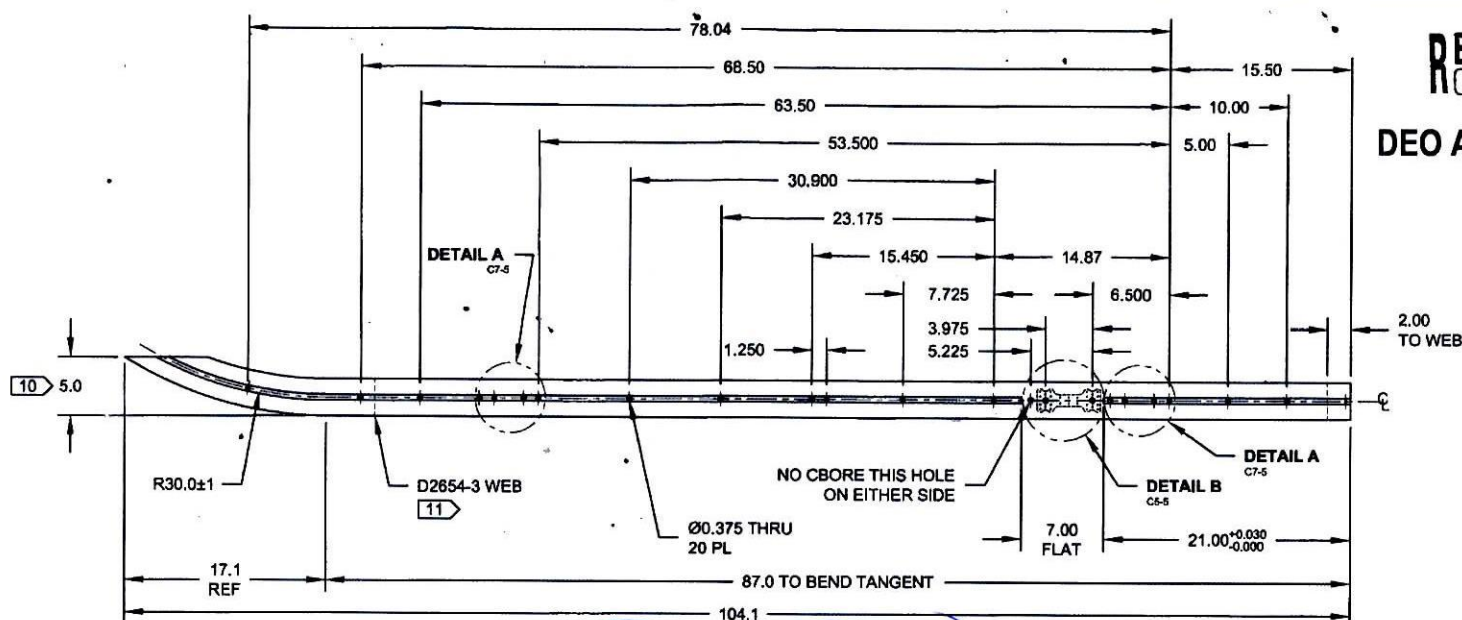


D3804-041 ASSEMBLY/FINISHING DETAIL

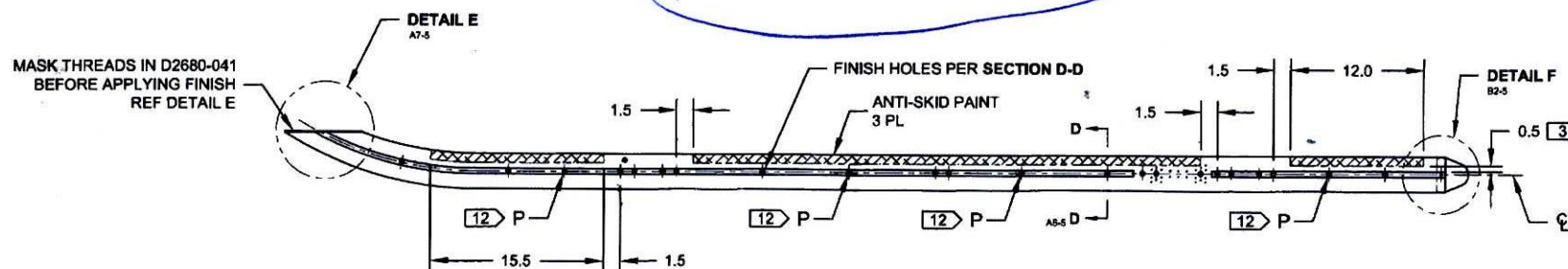
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CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 2 OF 5
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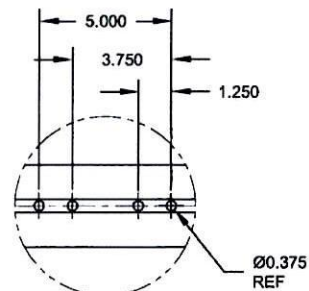
D3804-043 BENDING/DRILLING DETAIL



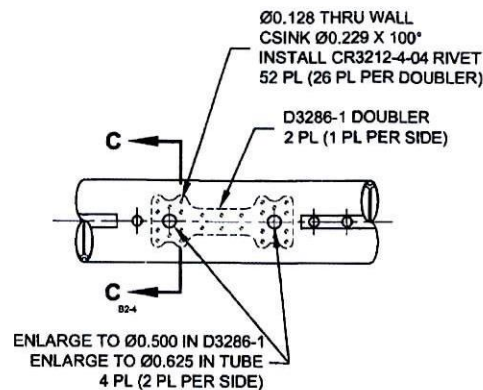
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MFG. APPR.	97	SHEET 3 OF 5	
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DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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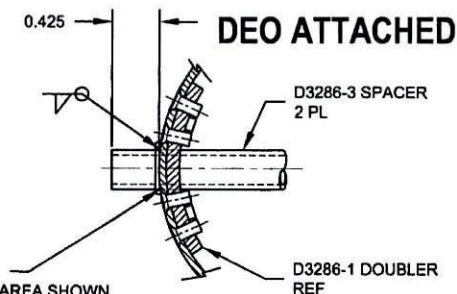
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DETAIL A D6-2
C2-2
D6-3
C2-3
SCALE NONE

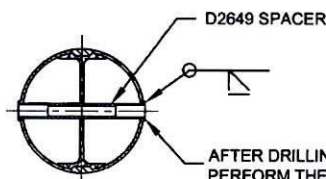


DETAIL B C3-2
C3-3
SCALE NONE



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



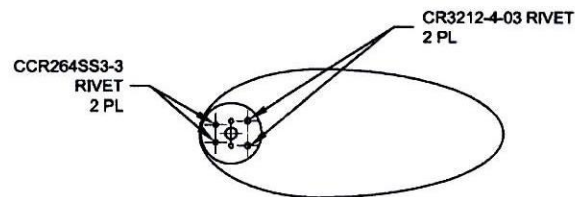
- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D A4-2
A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

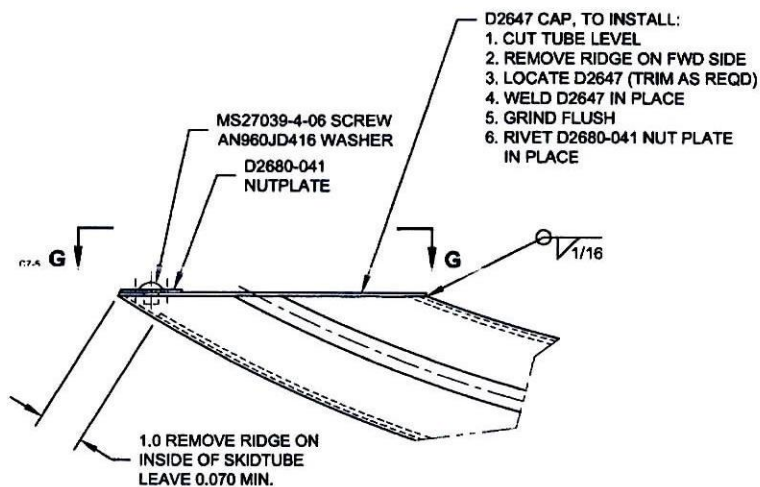
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CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 4 OF 5
APPROVED	97	TITLE	SCALE
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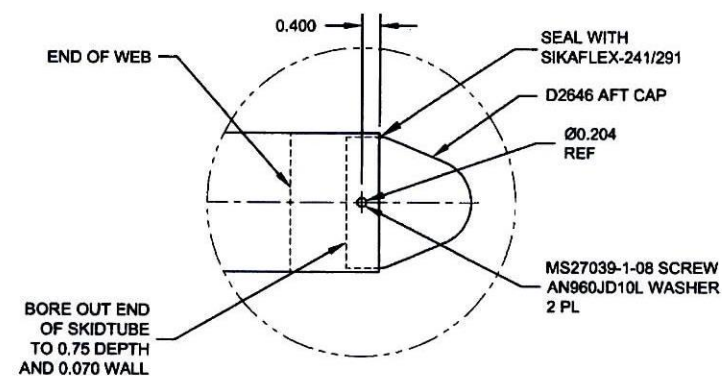
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VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2 B7-3



DETAIL F
SCALE NONE B2-2 B2-3

DESIGN	41	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	P	DRAWING NO. D3804	REV. A
MFG. APPR.	E	SHEET 5 OF 5	
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DRAWING NO. D3804	TITLE SKIDTUBE ASSEMBLIES, 206A/B	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3804-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>A.P.</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

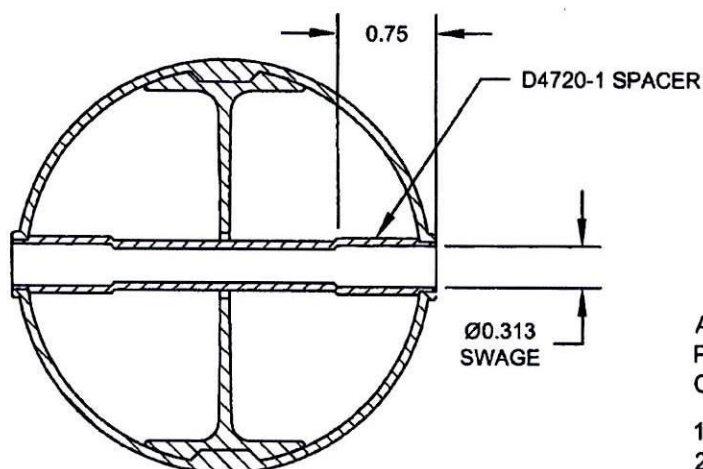
IS:

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	1	D2649	CROSS BOLT SPACER
18	19	D4720-1	SPACER

WAS:

19	20	D2649	CROSS BOLT SPACER
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ADD SECTION H-H BELOW, WHICH IS THE SAME SECTION VIEW AS SECTION D-D OF DWG.
C'BORED HOLES ARE NOW SWAGED PER SECTION H-H BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER SECTION D-D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).

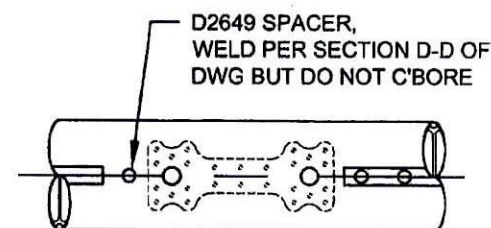


SECTION H-H

FOR Ø0.375 HOLES ONLY

FOR HOLES THAT ARE CURRENTLY C'BORED ONLY

NOT TO SCALE



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASE
2012-11-16
[Signature]

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 18 PL (-041) OR 19 PL (-043)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002